: BACKING PLATE

User:

Thursday, 28/05/2009 9:11:23 AM

Julie Dawson

Process Sheet

Drawing Name

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Job Number

: 48228

Estimate Number

: 10506

P.O. Number

First Issue

Written By

Previous Run

This Issue Prsht Rev. : 28/05/2009 : NC

: 11

: 31237

Type

: MACHINED PARTS

: D2228 **Part Number** . D2228 REV. B **Drawing Number**

: N/A **Project Number** : B **Drawing Revision**

Material

: 15/06/2009 **Due Date**

Qty:

40 Um:

Each

Checked & Approved By

Comment

: Est:B Re-format EC 00.08.22 est C

07.03.20 waterjet

EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description: 5052-H32 .063 Sheet

1.0

M5052H32S063



Comment: Qty.:

0.0227 sf(s)/Unit Total:

0.9080 sf(s)

5052-H32 .063 Sheet

Material: 5052-H32 Sheet (QQ-A-250/8) 0.063" thick

(M5052H32S.063)

Batch: <u>(03</u>

FLOW WATER JET

2.0

WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D2228

Dwg Rev:_____ Prog Rev:_



2-Deburr if necessary

B 9-6-15



QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

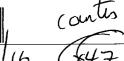
3.0

QC8

SECOND CHECK







Comment: SECOND CHECK

HAND FINISHING 5.0

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1



09-06-18

Dart Ae W/O:	. 	, 114	· · · · · · · · · · · · · · · · · · ·	ORK ORDER CHANGE	<u>S</u>	· · · · · · · · · · · · · · · · · · ·			
DATE	STEP	PROC	PROCEDURE CHANGE By			Date	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		.28 PAR#: 12 A. esolution: Seea p		tegory: Plan - Sm Fpb			A: 1		09.06.23
NCR: 4				DER NON-CONFORMAN					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	B Sign & Date	Sect	cation tion C	Approval Chief Eng	Approval QC Inspector
المارد	J. O.	3 Parts Scrap Parts Are Delamenteins of A seams of how & Bion cut RC. Mal in 5052. Process	posiur	Scrap and Dest. no Replace Cly (3)	09/06	16 07/6	66/16	psins	Solvelie

NOTE: Date & initial all entries

Teursday, 28/05/2009 9:11:23 AM Date: User: Julie Dawson **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: BACKING PLATE Job Number: 48228 Part Number: D2228 Job Number: Seq. #: **Machine Or Operation:** Description: POWDER COATING POWDER COATING 6.0 M111472 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 8:40 Am START TIME: OVEN TEMPERATURE: _ FINISH TIME: 7.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 8.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 9.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Ae	rospace	e Ltd						
W/O:			WO	RK ORDER CHANGE	S			
DATE STEP		PROCEDURE CHANGE			Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							E.	
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date:	
	R	esolution:	Disposition	1:	QA: N/C Clo	sed:	Date: _	
NCR:		,	WORK ORDE	ER NON-CONFORMAI	NCE (NCR))		
D.4.T.F.		Description of NC		Corrective Action Section B		Verification	Ammunual	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LT	'D	Work Order:	482291
	BACKING.		,
Description:	MOUNTING DLATE	Part Number:	BEEEG Q
	1000		
Inspection Dwg: DAAAR	Rev: R	·	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .171	100,-200.+	.173	8			
1.930	t/U10	1.920	X			
1.630	4-010	1.621	8			
. 306	1010	,361	×			
,300	4- 010	-300	8			
1.410	1010	1.414	×			
1,710	4010	しいら	8			
.063	400	600,	X	ļ		
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Measured by:	R	Audited by:	811	Prototype Approval:	N	
Date:	9-6-15	Date:	02/06/16	Date:		4

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	

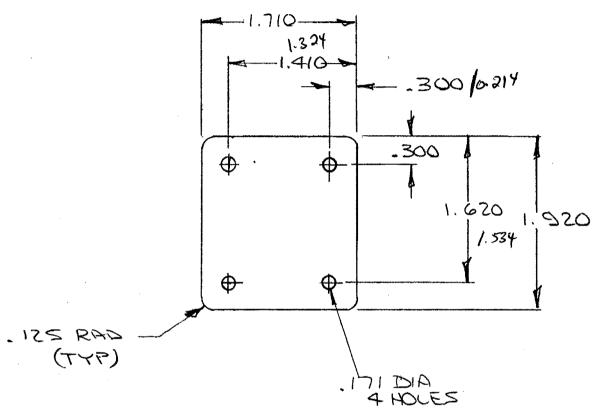






DRAI		94.2.23	DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA			
DESI B.V		94.3.23	DRAWING NO.	REV. B		
STRE	iss —		BACKINS	PLATE		
R	00.0	09.11	UPDATE FINISH SE	er & P		

RELEASED



MATERIAL:

5052-H32 .063 MICK (QQ-A-250/8)

FINISH : A CHEMICAL CONVERSION COAT PER DART QSI COS 4.1

POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI COS 4.3

SHOP COPY

RETURN TO

FINGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER